

SMALL FAB



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DAS
13
9-89

RBE-350HYD
Job Sheet 179280



Part No: RBE-350HYD

Job Qty: 5 ea

Part Name: Hydraulic Accumulator Fitting Gauge



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/15/18

Job Tracking No:

Due Date: 8/6/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE-350HYD REV:2 IPP REV:A 18.01.16 NEW ISSUE RQ VERIFIED BY: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	8/6/18	8/6/18	0.00	0.00	Start Up Small Fab-4		MCC
100	Small Fab	5 pcs	8/6/18	8/6/18	0.08	0.42	Small Fab-9		MCC DAS
110	QC	5 pcs	8/6/18	8/6/18	0.00	0.00	QC5		38
130	Packaging	5 pcs	8/6/18	8/6/18	0.00	0.00	Packaging3-2		MCC 9-89
140	QC21-FG	5 Ea	8/6/18	8/6/18	0.00	0.00	QC21		21 AUG 09 2018

Part Op 100 - 1- Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG. 2 Assemble as per dwg.
Descriptions: 3- Assemble using permatex thread sealant or equivalent as per note 2
130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
4053K751	Pressure Gauge, 0-300 Psi	5 Ea (1 ea)	90-Start up Operation	4x 5083992 1x 50625 12
AMF556	Bleeder	5 Ea (1 ea)	90-Start up Operation	5092228
PAR211P-4	1/4 NPT Square Plug	5 Ea (1 ea)	90-Start up Operation	5090826
PAR2203P-4	1/4 NPT Female "T" Fitting	5 Ea (1 ea)	90-Start up Operation	5090827
PAR209-4-2	1/4 NPT to 1/8 NPT Reducer Fitting	5 Ea (1 ea)	90-Start up Operation	2x 508925 3x 5084305

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	4053K751	5	21	0
	AMF556	5	22	0
	PAR209-4-2	5	29	0
	PAR211P-4	5	23	0
	PAR2203P-4	5	23	0

Part Specifications

Specifications could not be found.

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Container No: S098208

Part: RBE-350HYD

Job No: 179280

Serial No/Batch: S098208

Revision: 2

Inspector:

Exp Date:

Instructions:

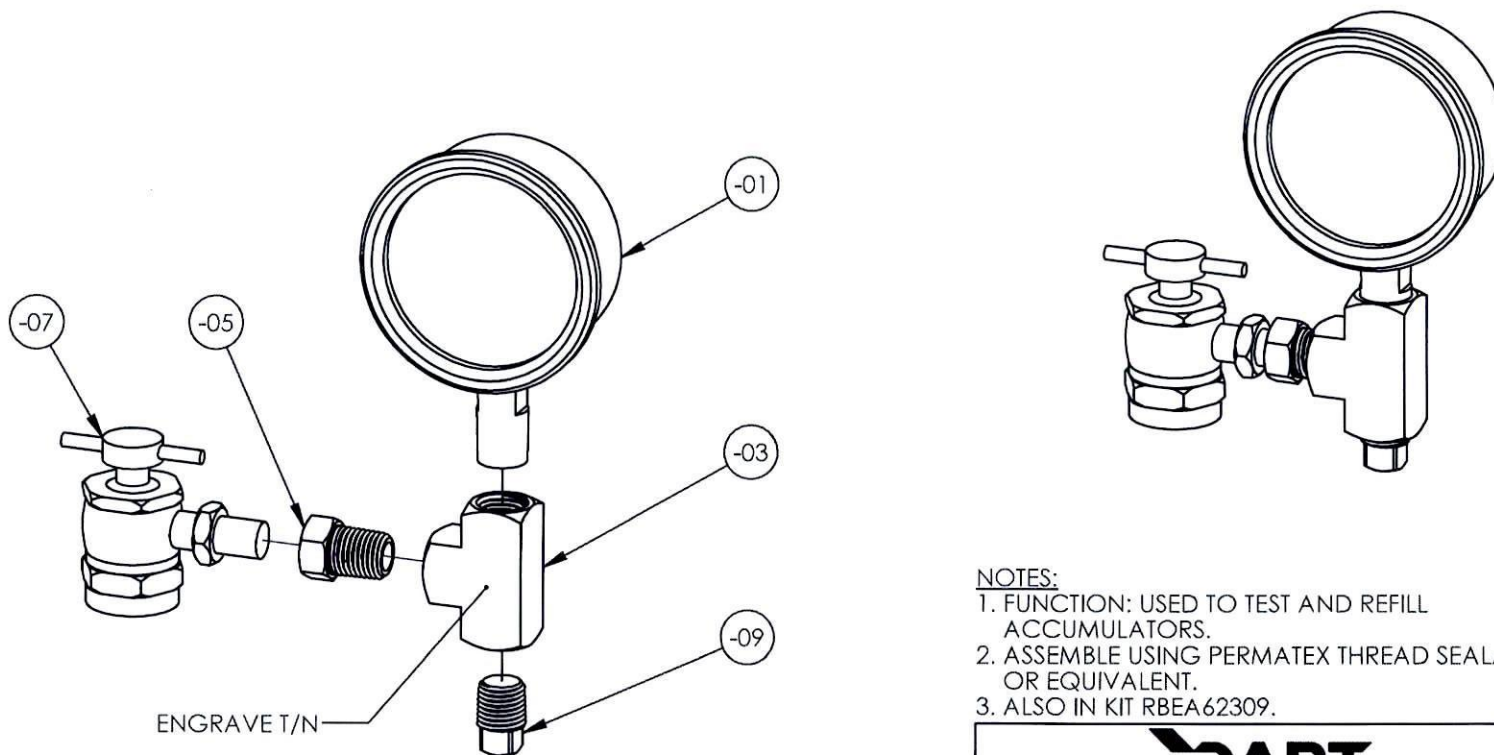
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Date: 08/01/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED PER HELI PRODUCTS TOOLS.	9/28/2009	WP	DW
1A		ADDED NOTE 2 TO USE PERMATEX THREAD SEALANT PER D.W.	5/9/2012	RJC	DW
1B		-01 CHD GAUGE WAS PACIFIC RUBBER #W1K9692040 IS PARAMOUNT SUPPLY #ASHCROFT 1008.	3/24/2014	RJC	RW
1C	14-0213	CHD TITLEBLOCK WAS RED BARN IS DART. RE-DRAWN IN SOLIDWORKS. ADDED ENGRAVE T/N NOTE. -01 CHD B/O INFO WAS #ASHCROFT 1008 IS #63-1008-S-02L-300#-XLL.	11/12/2014	DPD	JAG
2	16-0145	-01 CHD B/O REF WAS PARAMOUNT SUPPLY #63-1008-S-02L-300#-XLL IS McMaster-CARR #4053K751.	9/12/2016	DPD	JAG



NOTES:

1. FUNCTION: USED TO TEST AND REFILL ACCUMULATORS.
2. ASSEMBLE USING PERMATEX THREAD SEALANT OR EQUIVALENT.
3. ALSO IN KIT RBEA62309.

DART AEROSPACE	
TITLE HYD. ACCUM. FITTING GAUGE	
DWG NO. RBE-350HYD	REV 2
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:2	DATE 9/9/2009 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	-01	1	PRESSURE GAUGE, 0-300 PSI		0-300 psi (0-2,000 kPa) (McMASTER-CARR #4053K751)	1
		B/O	-03	1	1/4 NPT FEMALE "T" FITTING	BRASS	(PACIFIC RUBBER #PAR2203P-4)	1
		B/O	-05	1	1/4 NPT TO 1/8 NPT REDUCER FITTING	BRASS	(PACIFIC RUBBER #PAR209-4-2)	1
		B/O	-07	1	SCHRADER VALVE	S.S.	(PACIFIC RUBBER #AMF556)	1
		B/O	-09	1	1/4 NPT SQUARE PLUG	BRASS	(PACIFIC RUBBER #PAR211P-4)	1